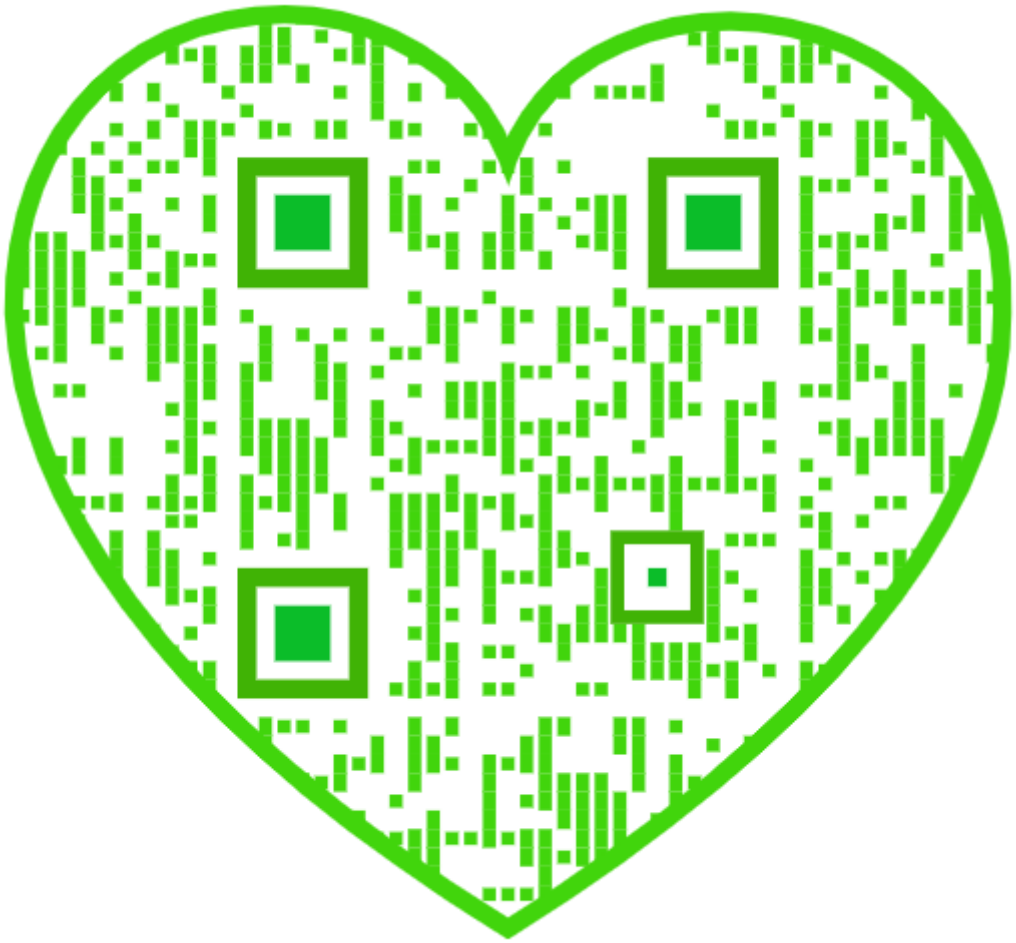
STAR

BONIFACIO ECHEVERRIA, S. A. - EIBAR (SPAIN)

AUTOMATIC PISTOLS

MODELS & CALIBERS	
SI .32 auto	= 7,65 mm.
S .380 auto	= 9 mm. short.
A .38 auto	= 9 mm. long
B 9 mm. Luger	= Parab.
M .38 auto	= 9 mm. long
P .45 auto	=



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LOADING AND FIRING OPERATION OF STAR PISTOLS

MODELS SI - S - A - B - M & P

TO LOAD THE MAGAZINE

Hold the magazine (53) in the left hand and place a cartridge on the front end of the magazine follower (54) until it can be slid in under the lips of the magazine well. Place another cartridge on top of the first one and force down and slide in. Follow this procedure until the magazine contains whatever cartridges are to be used.

Insert the magazine in the grip and push in until the magazine catch (28) engages in its slot in the magazine well.

TO LOAD THE PISTOL

Hold the pistol firmly in the right hand with the trigger finger outside the trigger guard and grasp the slide (65) firmly at its serrated section with the left hand and draw to the rear as far as it will go. (If the hammer (06) is cocked before the slide is withdrawn. the slide will come back much easier because it has less spring tension to overcome.)

Release the slide. The recoil spring (83) pulls it forward. The front breechblock face of the slide strips the cartridge from between the magazine lips and chambers it. The extractor (66) set in the face of the breechblock, snaps into the extracting groove of the cartridge case.

FIRING OPERATION

Hold the weapon firmly. Pressure on the trigger (19) will free the hammer (06) from the sear (14) to permit the hammer spring (09) pushing upward on the strut (which is

attached to the hammer) to rock the hammer forward on its axis (11) to strike the firing pin (70) mounted in its slot in the slide. The firing pin will fly forward to strike and fire the cartridge in the chamber.

When the powder in the cartridge case is ignited by the primer it generates a huge volume of gas. This gas expands in all directions, but as the least resistance is offered by the bullet directly ahead of it, it starts the bullet down the barrel (61), the gas pressure following along after it during its travel. Meanwhile, the outward thrust of the gases press the brass cartridge case firmly against the walls of the firing chamber, preventing gas from leaking back past the cartridge case.

The backward thrust of the gases inside the cartridge case press the case back against the breechblock which, in these pistols, is part of the slide.

The barrel and slide are locked together by the locking ribs on the top of the barrel which engage slots in the underside of the slide. They remain securely locked together during the moment of high breech pressure. They go back for a short distance firmly locked together.

As the bullet leaves the barrel and the chamber pressure falls to safe limits, the resilient brass case contracts to its normal size, moving away from the walls of the firing chamber. The barrel, swinging backwards on its link, which is firmly attached to the frame by the slide stop pin passing through it, is forced downward by the continuing rearward motion. The rear of the barrel strikes against its stop in the frame and its reaward action is halted: while the slide continues on backwards in a straight line in its grooves in the frame. The extractor, mounted in the breechblock face, carries the empty cartridge case out of the firing chamber with it.

When the breechblock end of the slide passes completely over the mouth of the magazine below, the ejection port in the right-hand side of the slide is fully exposed.

At thispoint the cartridge case strikes against the ejector in the frame which frees it from the extractor and hurls it out the right-top-side of the pistol.

The barrel bushing (78) around the muzzle of the barrel, which also locks and supports the recoil spring plug (84), presses back against the plug to compress the recoil spring (83) below the barrel over the recoil spring guide (80). This stores up energy for return movement of the slide.

The momentum of the slide strikes the hammer a sharp blow, driving it back to the full-cock position where the sear spring (16) forces the point of the sear (14) into the notch on the hammer to hold it at full-cock.

As the hammer (06) rocks back on its axis (11), it forces down the strut which is attached to it and the bottom of the strut, being mounted in the hammer spring plunger (10) above the hammer spring (09) in the grip, thrust downward to compress the hammer spring to provide energy for the next forward motion of the hammer.

At the first rearward motion of the slide, the beveled niche in the underside of the slide exerts pressure on the rounded head of the interrupter (25), forcing it down against the sear bar (23) to diesengage it from the tail of the sear (14) while finger pressure on the trigger is maintained.

The fore-end of the sear bar (23) presses against the trigger plunger (22) which returns the trigger to firin position, under the pressure of its spring (21) to permit engagement of the sear (14) when the slide next goes forward to the fully closed position and finger pressure on the trigger is momentarily released.

The magazine spring (56) forces the follower (54) up, pressing the cartridges inside the magazine well against the magazine retaining lips so that the head of the top cartridge is in direct line with the breechblock which will strip it forward into the firing chamber when the slide again goes forward.

When the magazine has been emptied, the slide stop (41) engages the slide and holds it open, thus serving as an indicator to remind the shooter that the empty magazine must be replaced by a loaded one.

Pressing down the slide stop will depress the magazine follower and permit the slide to go forward. If a loaded magazine is inserted before the slide stop is depressed, this forward motion of the slide will load the firing chamber, leaving the pistol ready for inmediate action.

SAFETIES

A thumb safety (36) is provided, which when at its topmost position, positively locks the hammer and slide.

TO DISASSEMBLE THE PISTOL FOR CLEANING PURPOSES

1. First, check to be sure that there is no cartridge left in the firing chamber. Depress the magazine catch button (29) on the left side of the pistol back of the trigger, and withdraw magazine.

2. Push the recoil spring plug (84) below the barrel muzzle inward with the index finger of the right hand (or butt of magazine) far enough to permit the barrel bushing (78) which locks the barrel to be turned to the right until the plug goes forward under the tension of the recoil spring. (Care should be taken not to let the plug to jump away). (See fig. 3 and 4).

3. Cock the hammer. Pull the slide back until the rear edge of the smaller recess in the lower edge of the slide is even with the rear end of the slide stop. Press the index finger of the right hand against the end of the slide stop which protudes from the opposite side of the frame obove the trigger guard and pull out the slide stop (See fig. 5).

4. As this slide stop is the medium by which the barrel link and slide are locked to the frame, withdrawing it releases the barrel and slide assembly, which may then together be drawn from the frame, carrying also the recoil spring, recoil spring guide and barrel bushing. (See fig. 6).

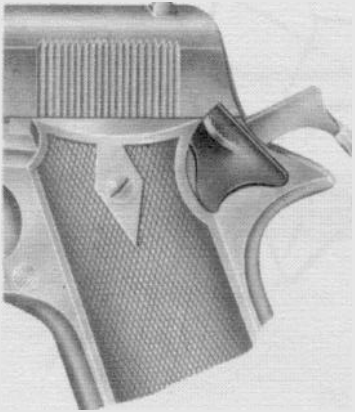
5. The barrel bushing, recoil spring and its guide may now be pulled out of the slide. (See fig. 7).

6. The barrel may then be drawn out if the link is tilted forward (See fig. 8).

This is all the disassembling necessary to properly clean the pistol.

TO REASSEMBLE THE PISTOL AFTER CLEANING

Reverse this procedure. When replacing slide on frame, pull slide back so that the barrel link lines up with the hole from which the slide stop was removed.



Fig, 1

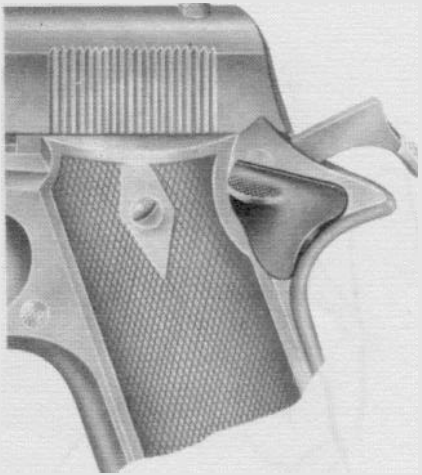


Fig. 2

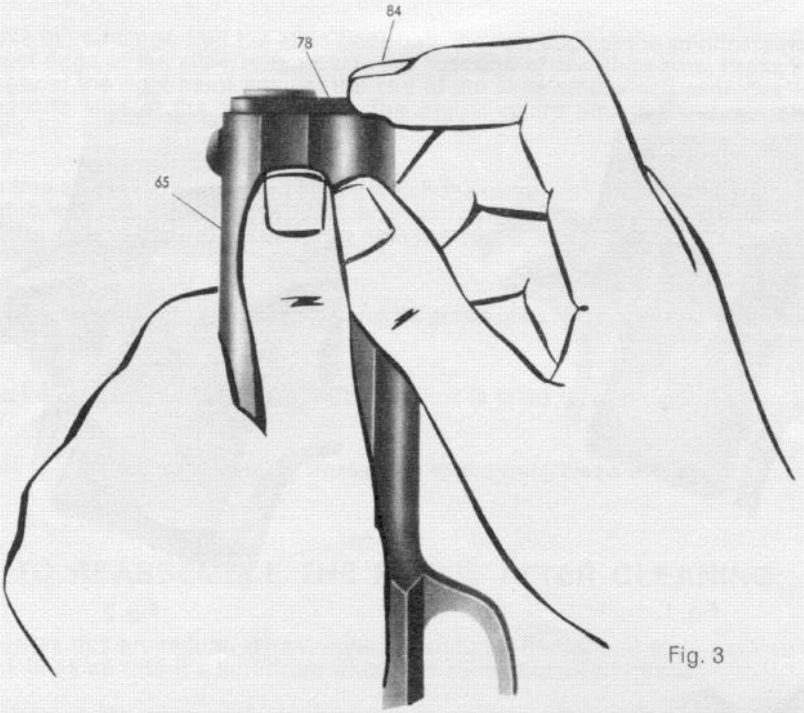


Fig. 3

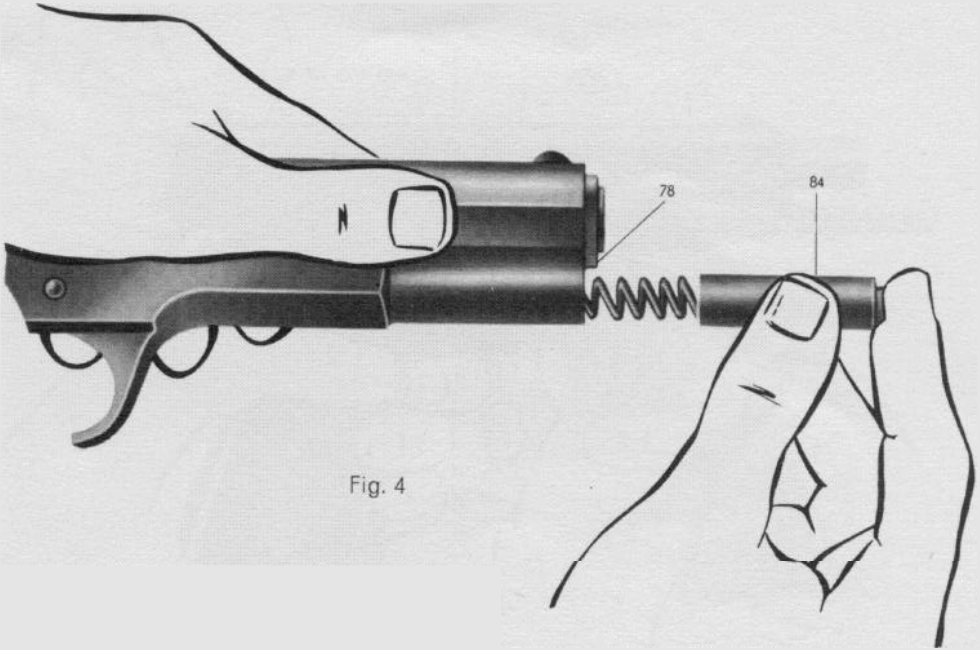


Fig. 4

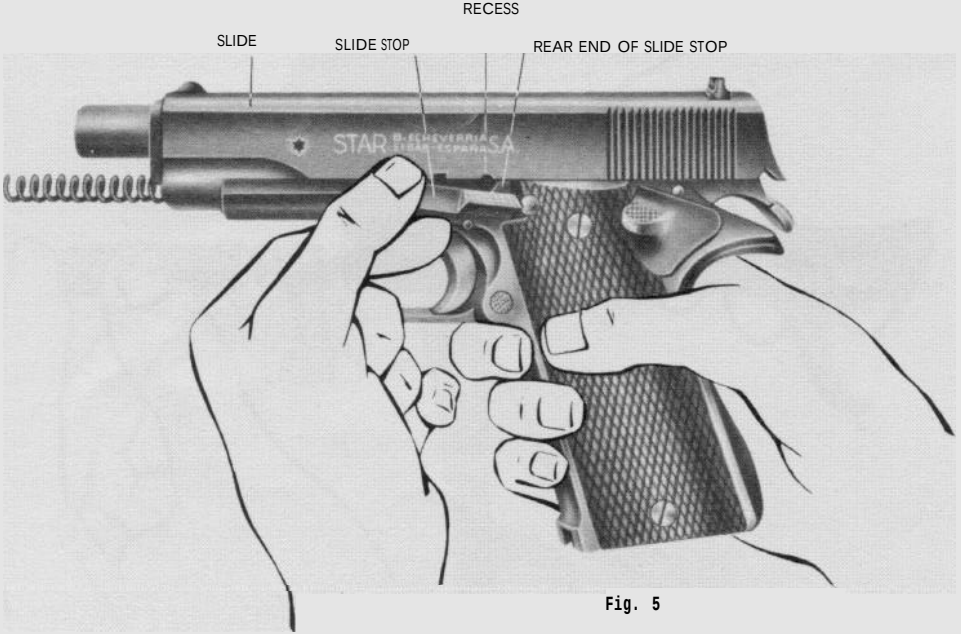


Fig. 5

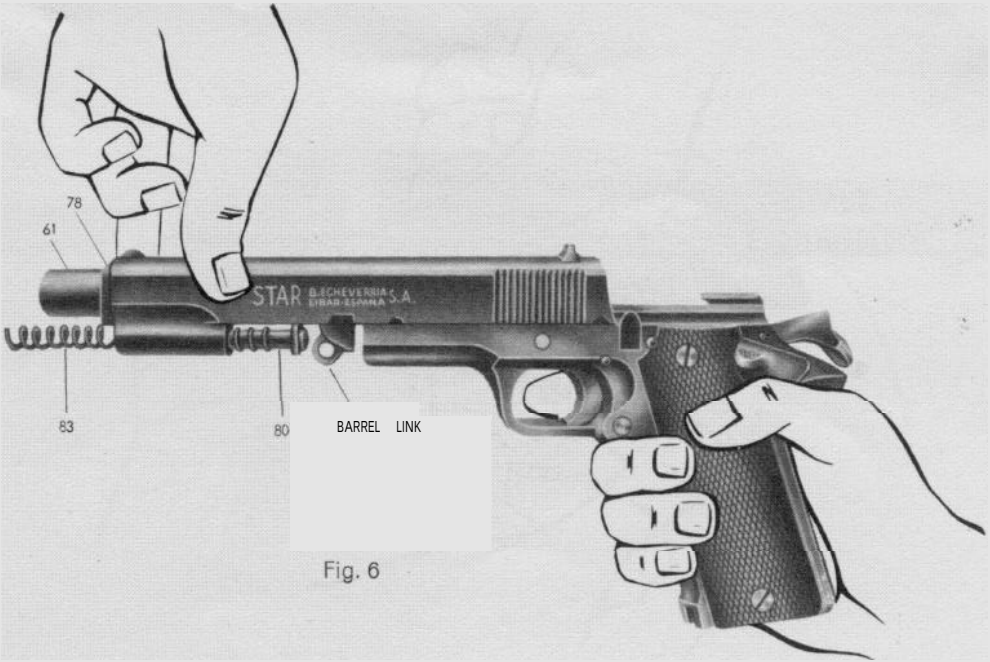
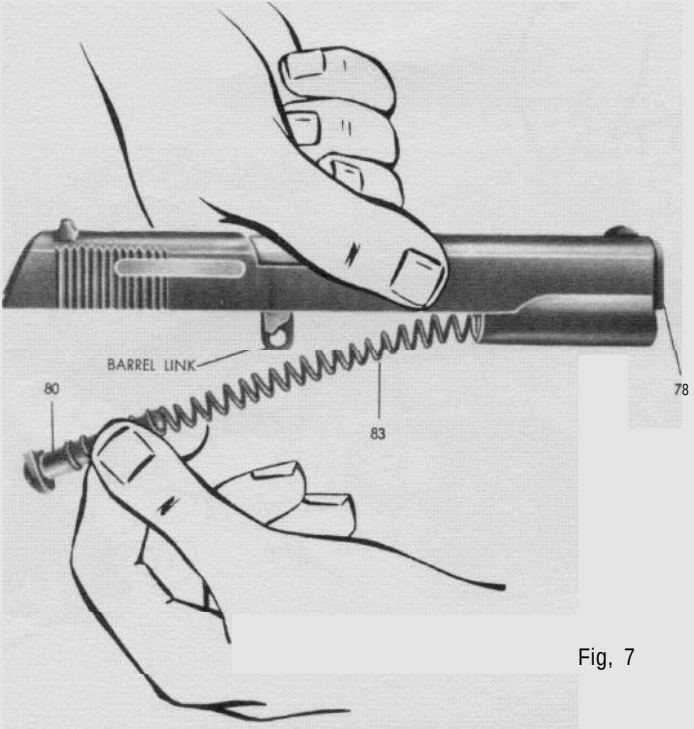


Fig. 6



Fig, 7

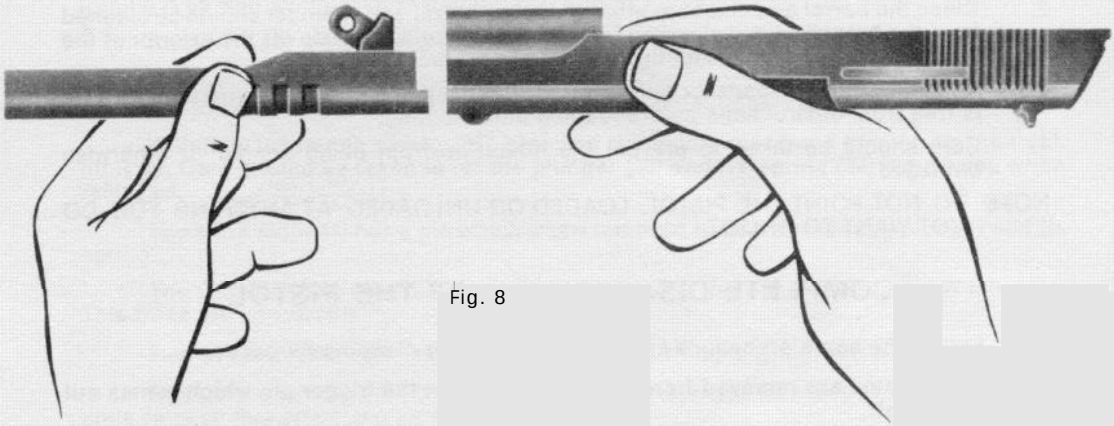


Fig. 8

IMPORTANT INSTRUCTIONS FOR BEST PERFORMANCE OF THE PISTOLS

1. All moving parts should be lightly oiled.
2. Clean the barrel and chamber after firing. The barrel and chamber should be cleaned from the breech avoid cleaning from the muzzle. Always wipe off the exterior of the pistol after use with a slightly oily cloth to protect the finish.
3. Use only standard loads for which the pistol is designed and make sure that the bore is free from obstructions before loading and shooting.
4. Care should be taken to prevent the magazine from being dented or otherwise damaged.

NOTE: DO NOT POINT THE PISTOL, LOADED OR UNLOADED, AT ANYTHING YOU DO NOT WANT TO SHOOT.

COMPLETE DISASSEMBLY OF THE PISTOL

Follow the same procedure as by disassembly for cleaning purposes.

Note: All the pins are removed from left to right, except the trigger pin which comes out to the left.

Remove grips (95 & 96b) unscrewing the four screws (97).

Holding the pistol in the left hand, depress the magazine catch button (29) with the index finger of the same hand far enough inwards to permit the catch lock (28) to be turned to the left by means of the cleaning rod. The complete magazine catch assembly may now be removed from the frame.

Remove pin (20) from the trigger (19) and both pieces will come out without difficutly, together with the sear bar (23) and interrupter (25), when pulling it downwards.

To remove the sear bar (23) from the trigger (19), push the sear bar pin out, thus freeing it as well as the trigger plunger (22) and its spring (21).

Remove sear pin **(15)** and this will free the sear spring (16).

Using a copper or brass punch, drive out the hammer pin (11) from right to left from the hammer (06). This releases both the spring (09) and plunger (10).

Withdraw the thumb safety (36), grasping the thumb piece and turning to the right, lift it up. Care should be taken to let the plunger (38) and its spring (39) jump away when released.

The slide stop (41) has a pin which when removed frees the retaining plunger and its spring.

The extractor (66) may now be removed, pushing the pin (67) from below upwards. This frees the spring (69).

Remove the rear sight (74) from right to left, drifting slightly with a copper punch.

Push the retaining pin (71) of the firing pin (70) upwards from the slide and tilting the slide release this piece and its spring (72).

TO REASSEMBLE THE PISTOL

Reverse the beforementioned procedure.

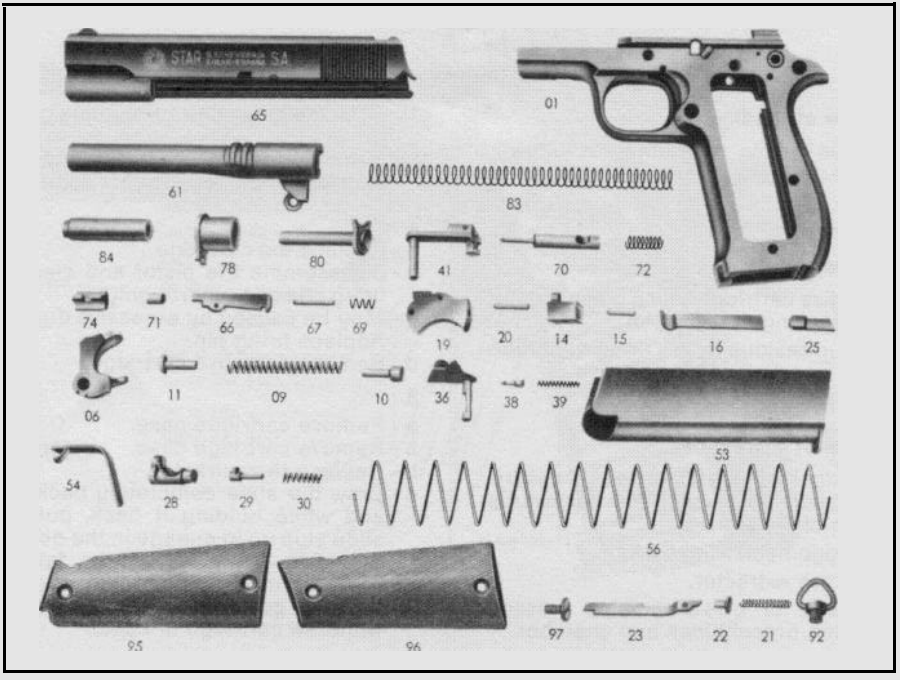
PISTOL
CHARGED
FULL-COCKED

LEFT-SIDE SECTIONAL VIEW OF "STAR" PISTOL

CHART OF POSSIBLE FIRING INTERRUPTIONS

CAUSES	CORRECTIONS
1. Failure of feeding:	**1.** Push the magazine completely into the
May be due to magazine not fully inserted into the grip or to magazine dents.	
a Magazine blown.	a Remove dent on magazine and if the magazine is faulty, correct same.
2. Failure to fire.	**2.**
a Defective cartridge which prevent complete locking of the pistol.	a Replace the cartridge.
b Built-up residue in the firing chamber.	b Disassemble the pistol and clean the firing chamber thoroughly.
c Firing Pin broken.	c May be caused by excessive dry firing. Replace firing pin.
d Defective cartridge primer.	d Remove defective cartridge.
3. Failure of extraction:	**3.**
a Cartridge has insufficient gas pressure, thus preventing complete backwards stroke of the slide.	a Remove cartridge case.
b Cartridge head (rim) broken.	b Remove cartridge case.
c Defective extractor.	c Replace the extractor.
d Cartridge or case remains pressed between breechblock and chamber.	d Draw the slide completely backwards and while holding it back, push the slide stop up to engage in the notch on the slide. (Care should be taken to prevent any casualty while operating with the gun). Remove magazine and withdraw cartridge or case.

"STAR" PISTOL PARTS



COMPONENT PARTS OF THE "STAR" PISTOL

Part N.º

01 Frame with Ejector,
06 Hammer with Strut and Pin.
09 Hammer Spring.
10 Hammer Spring Plunger.
11 Hammer Pin.
14 Sear.
15 Sear Pin.
16 Sear Spring.
19 Trigger.
20 Trigger Pin.
21 Trigger Plunger Spring,
22 Trigger Plunger.
23 Sear Bar.
25 Interrupter.
28 Magazine Catch Button.
29 Magazine Catch Lock.
30 Magazine Catch Lock Spring,
36 Safety thumb.
38 Safety Spring Plunger.
39 Safety Plunger Spring.

Part N.º

41 Slide Stop.
53 Magazine Tube with Floor Plate.
54 Magazine Follower.
56 Magazine Spring.
61 Barrel with Link and Pin.
65 Slide with Front Sight.
66 Extractor.
67 Extractor Pin.
69 Extractor Spring.
70 Firing Pin.
71 Firing Pin Retainig Pin,
72 Firing Pin Spring.
74 Sight, rear.
78 Barrel Bushing.
80 Recoil Spring Guide.
83 Recoil Spring
84 Recoil Spring Plug.
92 Swivel.
95. Grip, right
96 Grip, left.
97 Grip Screw

FOR REPLACEMENT PARTS SEE THE DEALER WHO SOLD YOU THIS GUN.

When ordering parts, please state model of pistol and its serial number.

NUMERICAL AND BALLISTIC DATA OF "STAR" PISTOLS

MODELS		SI	S	A	B	M	P
Caliber		.32 auto (7,65 mm)	.380 auto (9 mm short)	.38 auto	9 mm Luger Parabellum	.38 auto	.45 auto
Magazine Capacity	Rounds	9	8	8	8	9	7
Weight of pistol w/empty magazine	oz.	22	22	37-1/2	37-1/2	39-1/3	39-1/3
Overall length	in.	6 1/8	6 1/8	8 1/8	8 1/8	8 1/8	8 1/8
Height	in.	4-3/4	4-3/4	5-1/2	5-1/2	5-1/2	5-1/2
Width of Grip	in.	1	1	1	1	1-1/3	1-1/3
Barrel Length	in.	4	4	5	5	5	5
Length of Rifled Section	in.	2.40	2.40	4.13	4.13	4.13	4.13
Outside Dia. of barrel at chamber	in.	.551	.551	.669	.669	.691	.691
Outside Dia. of barrel at rifled section	in.	.421	.472	.512	.512	.512	.581
Number of Grooves		6	6	6	6	6	6
Depth of Grooves	in.	.0039	.0039	.0039	.0039	.0039	.0039
Width of Grooves	in.	.984	.1259	.1259	.1259	.1259	.1259
Twist of Rifling (One turn in)	in.	12.24	12.24	12.24	12.24	12.24	12.24
Length of Cartridge	in.	.984	.984	1.280	1.161	1.280	1.275
Weight of Cartridge Case	grains	42.4	51.8	67.5	61.5	67.5	86,5
*Weight of Bullet	grains	73	95	130	125	130	230
*Weight of Powder	grains	2.31	3.85	5.39	5.39	5.39	4.62
Total Weight of Cartridge	grains	117.71	150.65	202.89	191.89	202.89	321.12
*Muzzle Velocity	f. s.	1,072	1,050	1,206	1,206	1,285	784
*Muzzle Energy	ft. lbs.	185	228	410	410	410	309
*Chamber Pressure	p. s. i.	18.490	19,983	29,157	29,157	29,157	13,583
Penetration in 7/8" pine boards at 15 feet	in.	3.74	3.54	8.55	8.55	8.55	4.19

*The figures listed are only for reference and are not to be relied on for handloading.

STAR

BONIFACIO ECHEVERRIA, S. A.

EIBAR (SPAIN)

GRAFICAS VALDES - BILBAO